



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		19157 ✓	40/40
2	Machined By		V.T.L M/c Shop	Drg No - LSD 977
3	Pallet Die No.		12353 (40mm)	(Rev of)
4	Die Category	Drg. No.	Senior ✓	
5	Out Side Diameter	Drg. No.	500 mm ✓ Step 002 492	Step length - 13.5mm ✓
6	Inside Diameter	Drg. No.	Ⓐ 420.12 mm ✓	
7	Width of Pellet Die	Drg. No.	152mm ✓	
8	Grooves as per Drawing	Drg. No.	11x5x3mm / 11x5x3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 8 Both Side ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		456mm ✓	
13	Tapping Hole Diameter		03/4" Check by 3/4" Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 16.4mm Tapping Depth - 14.6mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 26/08/24

1	As per programme no.		—
2	Gun Drilling Work Completed On		—
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60°

1	Counter Sinking Depth & Finish	OK							Row - 21
2	External Relief Dia	4.5mm	outside	Inner					
3	External Relief Depth	4mm	0						
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		26	08	24				

### Inspected By (Sign) & Date

Ramanpreet Singh 26/08/24

Reviewed by  
27/08/24

Reviewed by (Engineer-CNC)

Manager-QA